



## PATENT ABSTRACTS OF JAPAN

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(54) WIRE ELECTRIC DISCHARGE MACHINING

(57) Abstract:

precision can be kept favourably.

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**PURPOSE:** To carry out the unmanned work with high precision and in a wide application range by electric-discharge-removing a scrap region with high efficiency, leaving a finished portion, by using a wire electrode having a large diameter and carrying out the work with high precision by an electrode having a small diameter.

**CONSTITUTION:** A workpiece 10 is installed onto a wire electrode feeding device equipped with two pairs of pipe guides 36a and 36b. A scrap region 2 is electric-discharge-removed along a wire electrode path 3 in a desired shape 1 by a device equipped with a wire electrode 38 having a large diameter until a finishing portion on one side (I) is left. Then, the workpiece 10 is transferred onto a device equipped with an electrode 38b having a small diameter, and the rest finished portion (I) is electric-discharge-removed in one or several times, and the finishing to a desired shape 1 is performed. In the above-described operation, the application range to a workpiece having large shape and plate thickness can be spread, and the high working

